



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5425-043
Job Sheet 196257



Part No: D5425-043

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/10/19

Job Tracking No:

Due Date: 7/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5425 REV.B IPP REV:A 17.11.02 NEW ISSUE DD VERF:JFS IPP REV:B 18.08.20 AS PER DWG REV.B DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/30/19		0.00	8.24	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4	TF	
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	HAAS 4 Axis - B4B	1 pcs	7/30/19		1.00	22.77	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 2	1 pcs	7/30/19		0.00	0.00	QC 2 - 1		<i>1A MM. 201/07/17</i> <i>kt 19-07-18</i>
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S193355



Part: D5425 - 043

Job No: 196257

Serial No/Batch: S193355

Revision: B

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/24/19

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				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
140 QC 8	1	7/30/19	0.00 0.00	QC 8 - 12	m/19/07/22
	pcs			QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
150 Handfinish - 1-1 Chemical-B4B	1	7/30/19	0.00 0.24	Handfinish - 1 - 1 - B4B	
	pcs			Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	JTL
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 -	

				B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 QC 7	1 pcs	7/30/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	MB
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
170 Skidtubes - Bend - 2 - B4B	1 pcs	7/30/19	0.50 2.63	Skidtubes - Bend - B4B	MB DD
180 QC 5	1 pcs	7/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BE
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	

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					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
190 Skidtubes - 2 - B4B	1 pcs	7/30/19	0.00	8.24	Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	MLC
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
200 QC 5	1 pcs	7/30/19	0.00	0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
210 Handfinish - 6-1- Touch Up- B4B	1 pcs	7/30/19	0.00	0.24	Handfinish - 6 - 1 - B4B	
					Handfinish - 6 - 2 - B4B	
					Handfinish - 6 - 3 - B4B	JUL 30 2019
					Handfinish - 6 - 4 - B4B	
					Handfinish - 6 - 5 - B4B	
					Handfinish - 6 - 6 - B4B	
					Handfinish - 6 - 7 - B4B	
					Handfinish - 6 - 8 - B4B	
					Handfinish - 6 - 9 - B4B	
					Handfinish - 6 - 10 - B4B	
					Handfinish - 6 - 11 - B4B	
					Handfinish - 6 - 12 - B4B	
					Handfinish - 6 - 13 - B4B	
					Handfinish - 6 - 14 - B4B	
					Handfinish - 6 - 15 -	

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				B4B	
				Handfinish - 6 - 16 - B4B	
				Handfinish - 6 - 17 - B4B	
				Handfinish - 6 - 18 - B4B	
				Handfinish - 6 - 19 - B4B	
				Handfinish - 6 - 20 - B4B	
				Handfinish - 6 - 21 - B4B	
				Handfinish - 6 - 22 - B4B	
220 QC 7	1 pcs	7/30/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	MLG
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
230 Skidtubes - 3 - B4B	1 pcs	7/30/19	0.00 8.24	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	MLG
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
240 QC 5	1 pcs	7/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				Plex 6/10/19 3:22 PM Dart.lajeunesse.marie	

						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	DAS AUG 01 2019 68
						QC 5 - 9	9-89
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
250 Handfinish - 6-2- Touch Up- B4B	1 pcs	7/30/19	0.00	0.33	Handfinish - 6 - 1 - B4B		
					Handfinish - 6 - 2 - B4B		
					Handfinish - 6 - 3 - B4B	AUG 01 2019	
					Handfinish - 6 - 4 - B4B		
					Handfinish - 6 - 5 - B4B		
					Handfinish - 6 - 6 - B4B		
					Handfinish - 6 - 7 - B4B		
					Handfinish - 6 - 8 - B4B		
					Handfinish - 6 - 9 - B4B		
					Handfinish - 6 - 10 - B4B		
					Handfinish - 6 - 11 - B4B		
					Handfinish - 6 - 12 - B4B		
					Handfinish - 6 - 13 - B4B		
					Handfinish - 6 - 14 - B4B		
					Handfinish - 6 - 15 - B4B		
					Handfinish - 6 - 16 - B4B		
					Handfinish - 6 - 17 - B4B		
					Handfinish - 6 - 18 - B4B		
					Handfinish - 6 - 19 - B4B		
					Handfinish - 6 - 20 - B4B		
					Handfinish - 6 - 21 - B4B		
					Handfinish - 6 - 22 - B4B		
					260 QC 7	1 pcs	7/30/19
QC 7 - 13							
QC 7 - 14							
QC 7 - 15							
QC 7 - 17							
QC 7 - 18							
QC 7 - 19							
QC 7 - 2							
QC 7 - 28							
QC 7 - 3							
QC 7 - 30							
QC 7 - 34							

					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	AR 17-8-3
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
270	Spray Paint - 2 - B4B	1 pcs	7/30/19	0.00 0.50	Spray Paint - 1 - B4B	AR 17-8-3
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
280	QC 14	1 pcs	7/30/19	0.00 0.00	QC 14 - 15	AR 17-8-4
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
282	Outsource - 11 - Paint	1 pcs	7/30/19		ATE003-VC	2
284	Packaging 2-1 - Receive - B4B	1 pcs	7/30/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	

DAS
15
9-89

						Packaging 2 - 25 - B4B	
						Packaging 2 - 26 - B4B	
						Packaging 2 - 27 - B4B	
						Packaging 2 - 28 - B4B	
						Packaging 2 - 29 - B4B	
						Packaging 2 - 30 - B4B	
						Packaging 2 - 31 - B4B	
						Packaging 2 - 32 - B4B	
						Packaging 2 - 33 - B4B	
						Packaging 2 - 34 - B4B	
						Packaging 2 - 35 - B4B	
						Packaging 2 - 36 - B4B	
286 QC 6	1 pcs	7/30/19	0.00	0.00		QC 6 - 9	
						QC 6 - 68	
						QC 6 - 61	
						QC 6 - 40	
290 Handfinish - 4-1-Assembly-B4B	1 pcs	7/30/19	0.00	0.24		Handfinish - 4 - 1 - B4B	el 19-8-6
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
300 QC 5	1 pcs	7/30/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	

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				QC 5 - 40	
310	Packaging 3-1 - Stock - B4B	1 pcs	7/30/19	0.00	0.00
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
320	QC 21 - SA	1 pcs	7/30/19	0.00	0.00
				QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

DAS AUG 07 2019

Part Op 110 - 1-Cut tube to finished length as per Dwg. 2-Debur ends as per Dwg.
 Descriptions: 120 - 1-Machine as per Dwg. and Folio FB536 DWG REV: B FOLIO REV: AA 2-Debur as per Dwg.
 130 - (QC2- Inspect parts off machine FAI/FAIB)
 140 - (QC8- Inspect parts - second check)
 150 - 1-Scrub inside of tube with medium scotchbright.
 160 - (QC7-Inspect Chemical Conversion Coat)
 170 - 1-Bend Aft end of tube as per Dwg. and Folio 4.5. Insert Bending mandrel DT 10328 at 20.0" from aft end. Use buggy A,B,C. to stabilize tube. HEIGHT 4.5 2-Bend Forward end of tube as per Dwg. and Folio 7.313. Insert Bending mandrel DT 10328 at 12.0" from fwd end. Use buggy A,B,C To stabilize tube. HEIGHT 7.313 3-Record dimensions on work order.
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - 1-Drill remaining holes of DETAIL M, N, P. USING DT10340 A,B,C,D 2-Open holes to finished size as per Dwg. 3-Debur holes per QSI002 section 4.2.3 and blow out all chips from inside of tube.
 200 - (QC5- Inspect part completeness to step on W/O)
 220 - (QC7-Inspect Chemical Conversion Coat)
 230 - 1-Wet install crossbolt spacers of Section G-G. Swage to 0.437 as per Dwg. PRIMER B Start
 Time: Finish Time: ***CURE TIME 6HRS. BEFORE PROCEEDING TO NEXT STEP*** 2-Swage crossbolt spacers of Section F-F to 0.313 as per Dwg. 3-Trim / Grind flush, deburr. 4-Identify per QSI 044 6.1
 240 - (QC5- Inspect part completeness to step on W/O)
 250 - (Touch up alodine) ***DO NOT SUBMERGE TUBE IN DEOXODIZER***
 260 - (QC7-Inspect Chemical Conversion Coat)
 270 - (Spray Paint / NDT Room) ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 5198,114 2-PAINT AS PER DWG AND

QSI005 4.2.2.4 PAINT BATCH: 5198581**280** - (QC14- Inspect Spray Paint)**282** - ***PLUG ALL CROSSBOLT SPACER HOLES PRIOR TO PRIME AND PAINT*** 1-PRIME AS PER DWG AND

QSI005 4.2.1.3.3 PRIMER BATCH: _____ 2-PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT

BATCH: _____

284 - C OF C IS REQUIRED**290** - (Assemble as per dwg) 1-Install FWD and AFT cap seal with sikaflex-241 / 291 B 5163432 Exp; 19-12-8 eStart time: _____ Finish time: _____ 2-Coat all exposed hardware with LPS Procyon B. Remove any excess off with MEK degreaser. A/R LPS Procyon B 5133686**300** - (QC5- Inspect part completeness to step on W/O)**310** - (Identify as per dwg & Stock Location: _____)**320** - (QC21- Final Inspection - Work Order Release)**Job BOM**

Part / Item	Component Name	Quantity	Operation	Container
D6028-195	Crosstube Material, 7075-T73/T73511	1 pcs (1 ea)	110-Skidtubes - 1	<u>5187596</u>
D5518-1	Crossbolt Spacer	18 pcs (18 ea)	230-Skidtubes - 3 - B4B	<u>5183903</u>
D5512-1	Crossbolt Spacer	12 pcs (12 ea)	230-Skidtubes - 3 - B4B <u>13x</u>	<u>5187624</u>
AN3C5A	Bolt	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5192141</u>
D3672-1	Washer, Phenolic	6 pcs (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5164009</u>
D5483-041	Tow Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5199399</u>
D5484-041	Aft Cap Assembly	1 pcs (1 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5206349</u>
NAS1149C0332R	Washer	6 Ea (6 ea)	290-Handfinish - 4-1-Assembly-B4B	<u>5193136</u>

Job Allocations

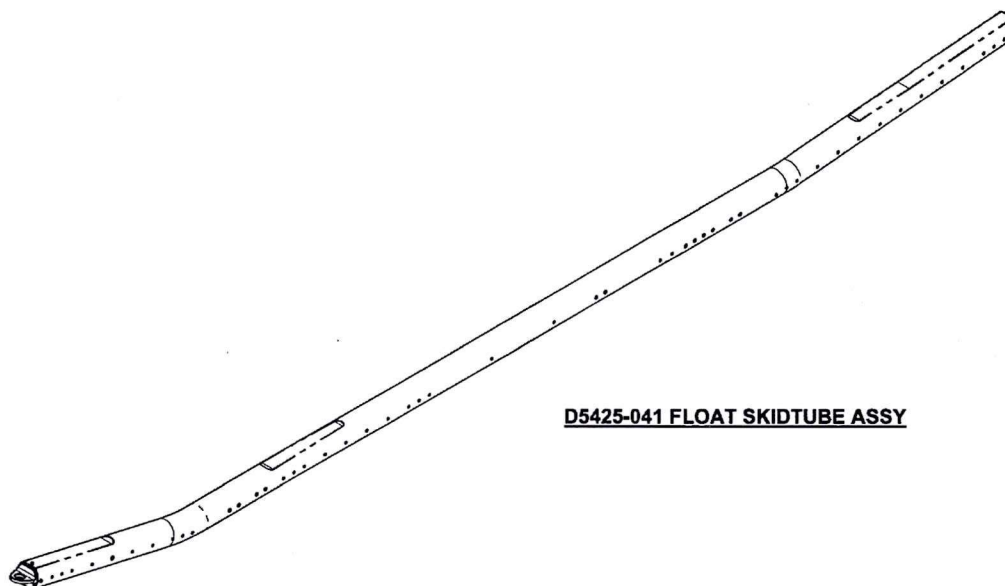
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D6028-195	1	15	0
230-Skidtubes - 3 - B4B	D5512-1	12	118	0
	D5518-1	18	236	0
290-Handfinish - 4-1-Assembly-B4B	AN3C5A	6	1,084	0
	D3672-1	6	1,669	0
	D5483-041	1	10	0
	D5484-041	1	9	0
	NAS1149C0332R	6	2,780	0

Part Specifications

Specifications could not be found.

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QTY -041	P/N	DESCRIPTION
X	D5425-041	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-1	FLOAT SKIDTUBE
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
37	D5518-1	CROSSBOLT SPACER
6	AN3C5A	BOLT
6	NAS1149C0332R	WASHER



D5425-041 FLOAT SKIDTUBE ASSY

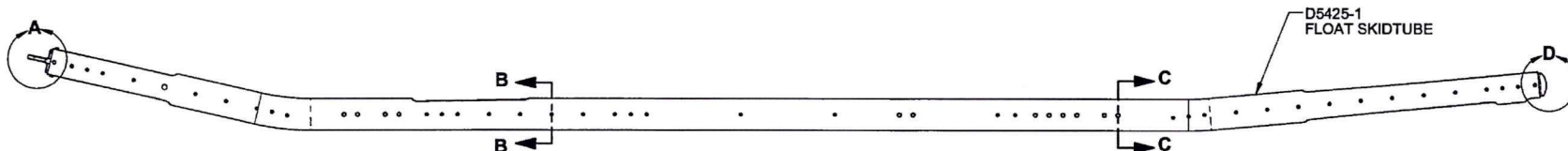
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196 257 MJS
19-06-11

RELEASED

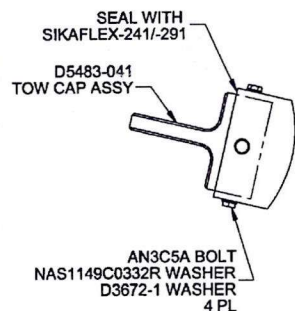
2018 AUG 16
ECN 18-736

B	CHANGE HOLE SIZE TO IMPROVE OFF-AXIS SWAGING IN SHEETS 5 AND 6 (NCR18-6741). PICTORIAL UPDATE DUE TO CHANGES IN D5483-1.	NO	18.02.05
A	NEW ISSUE	NO	17.07.19
REV.	DESCRIPTION	BY	DATE
DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 1 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
DATE	18.02.05	COPYRIGHT © 2017 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

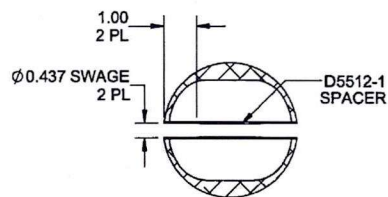
APPROVED



D5425-041 FLOAT SKIDTUBE ASSY

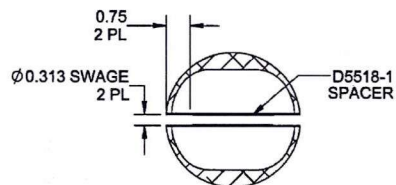


DETAIL A
SCALE 4X



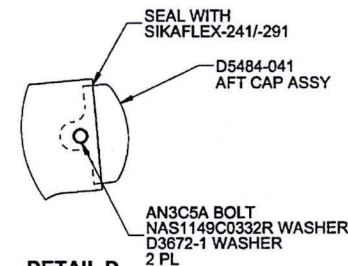
AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR $\phi 0.508$ HOLES ONLY:
1. WET INSTALL D5512-1 SPACER PER QSI 002
2. SWAGE TO $\phi 0.437$ X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION C-C
SCALE 4X
12 PL



AFTER DRILLING AND BENDING, PERFORM THE FOLLOWING FOR $\phi 0.377$ HOLES ONLY:
1. INSERT D5518-1 SPACER
2. SWAGE TO $\phi 0.313$ X 0.75 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

SECTION B-B
SCALE 4X
37 PL



DETAIL D
SCALE 4X

RELEASED

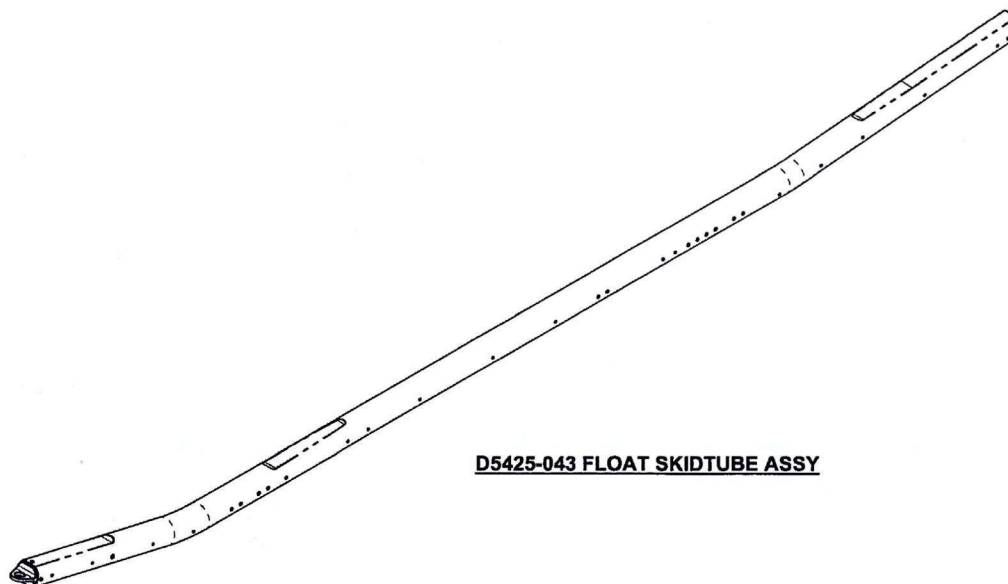
2018 AUG 16

- NOTES:**
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3
PAINT PER DART QSI 005 4.2.2.4
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 54.5lbs
8) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"

APPROVED

DESIGN	NO	DART AEROSPACE USA, INC.	
DRAWN	NO	EUGENE, OR	
CHECKED	ZF	DRAWING NO.	REV. B
MFG. APPR.	DD	D5425	SHEET 2 OF 10
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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QTY -043	P/N	DESCRIPTION
X	D5425-043	FLOAT SKIDTUBE ASSY
6	D3672-1	WASHER
1	D5425-3	FLOAT SKIDTUBE (DART TRIBAG)
1	D5483-041	TOW CAP ASSY
1	D5484-041	AFT CAP ASSY
12	D5512-1	CROSSBOLT SPACER
18	D5518-1	CROSSBOLT SPACER
6	AN3C5A	BOLT
6	NAS1149C0332R	WASHER

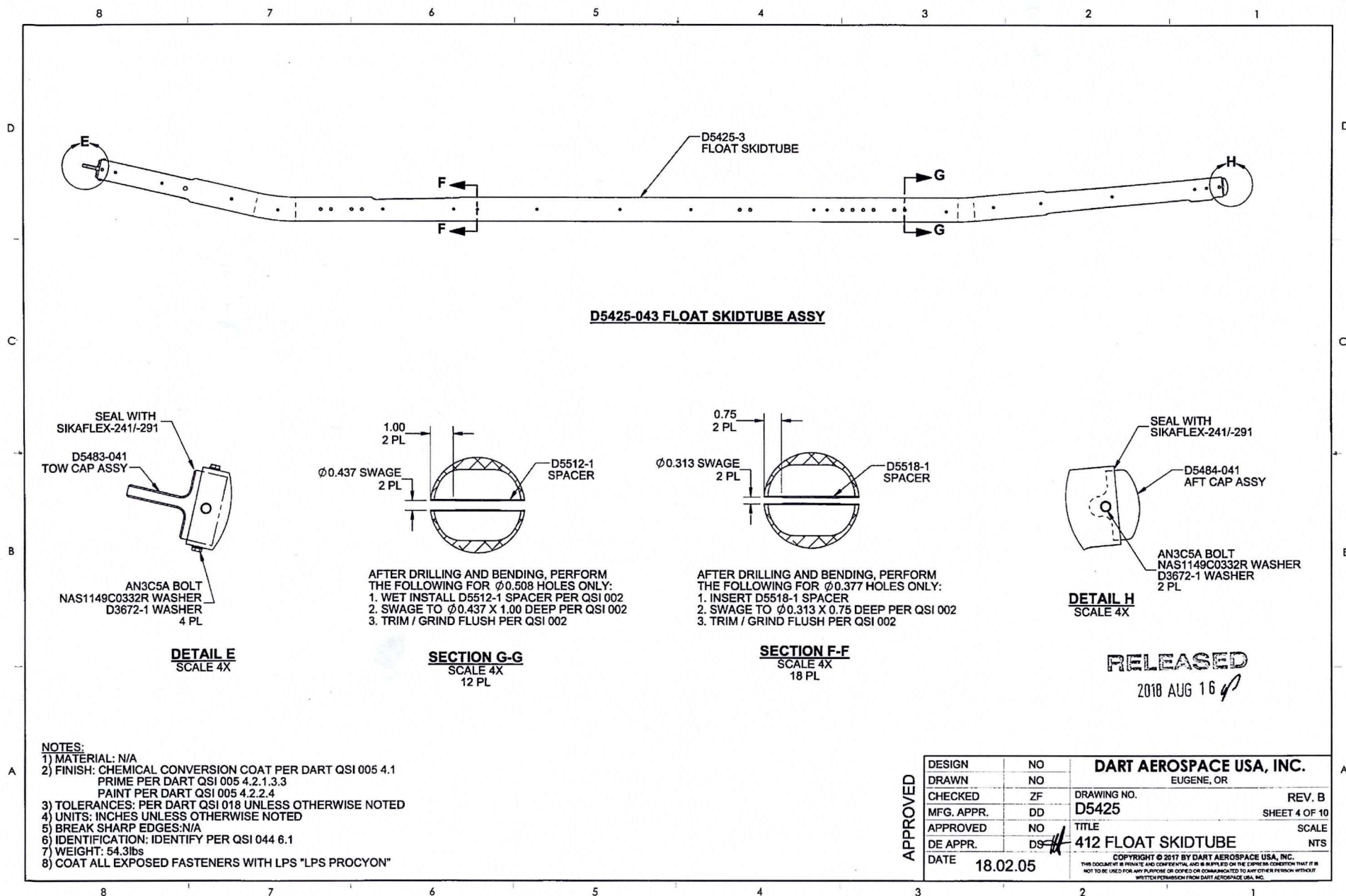


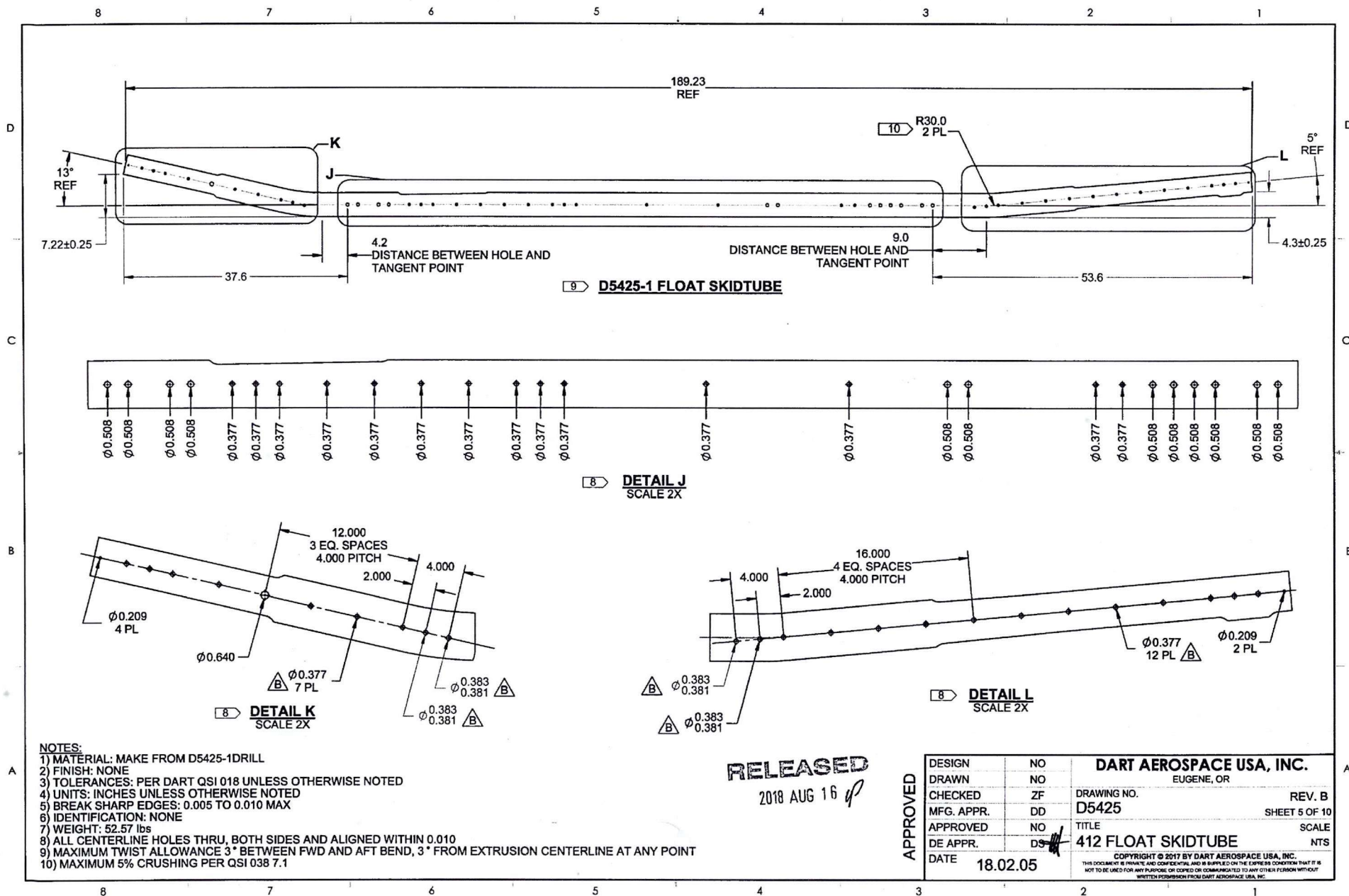
D5425-043 FLOAT SKIDTUBE ASSY

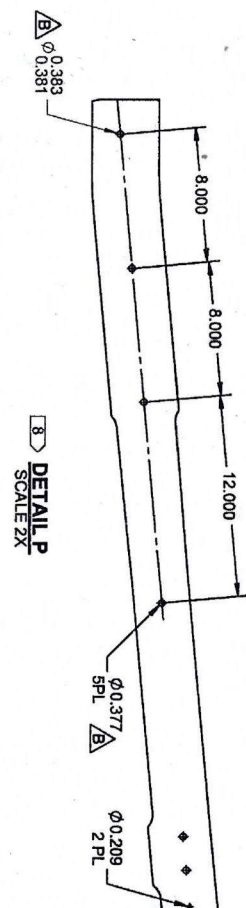
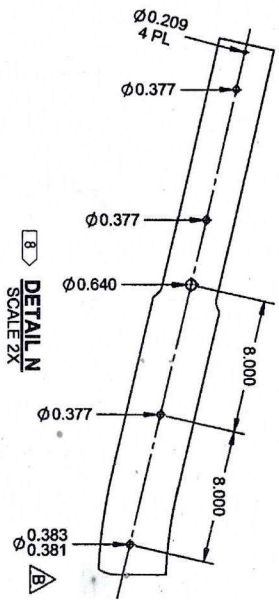
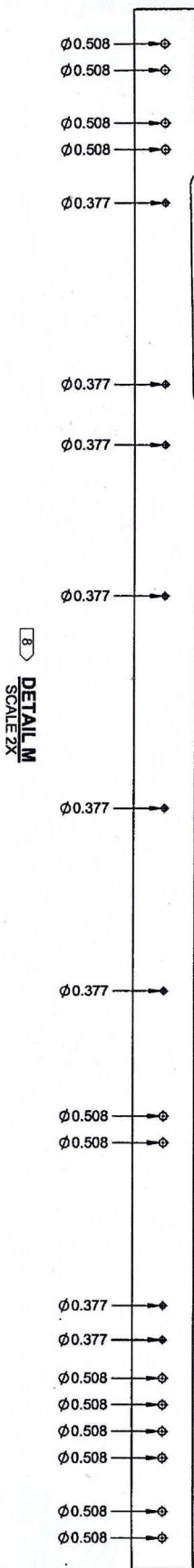
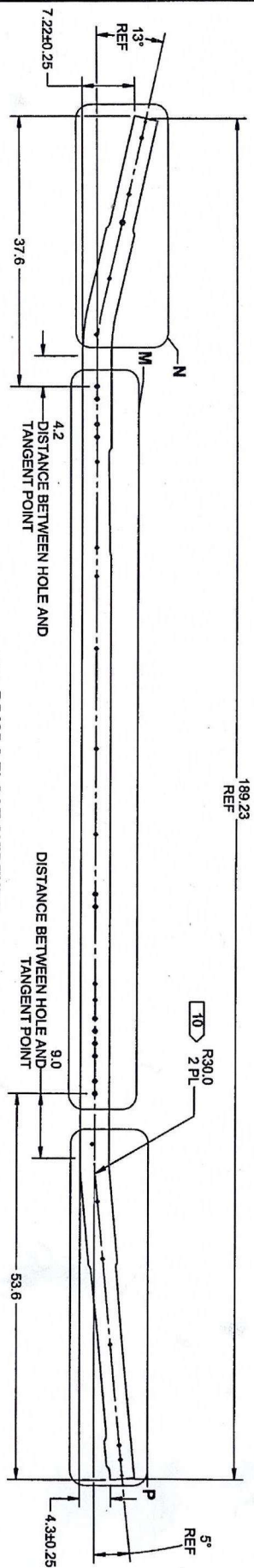
RELEASED

2018 AUG 16 *47*

APPROVED	DESIGN	NO	DART AEROSPACE USA, INC. EUGENE, OR	
	DRAWN	NO		
	CHECKED	ZF	DRAWING NO.	REV. B
	MFG. APPR.	DD	D5425	SHEET 3 OF 10
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DS	412 FLOAT SKIDTUBE	NTS
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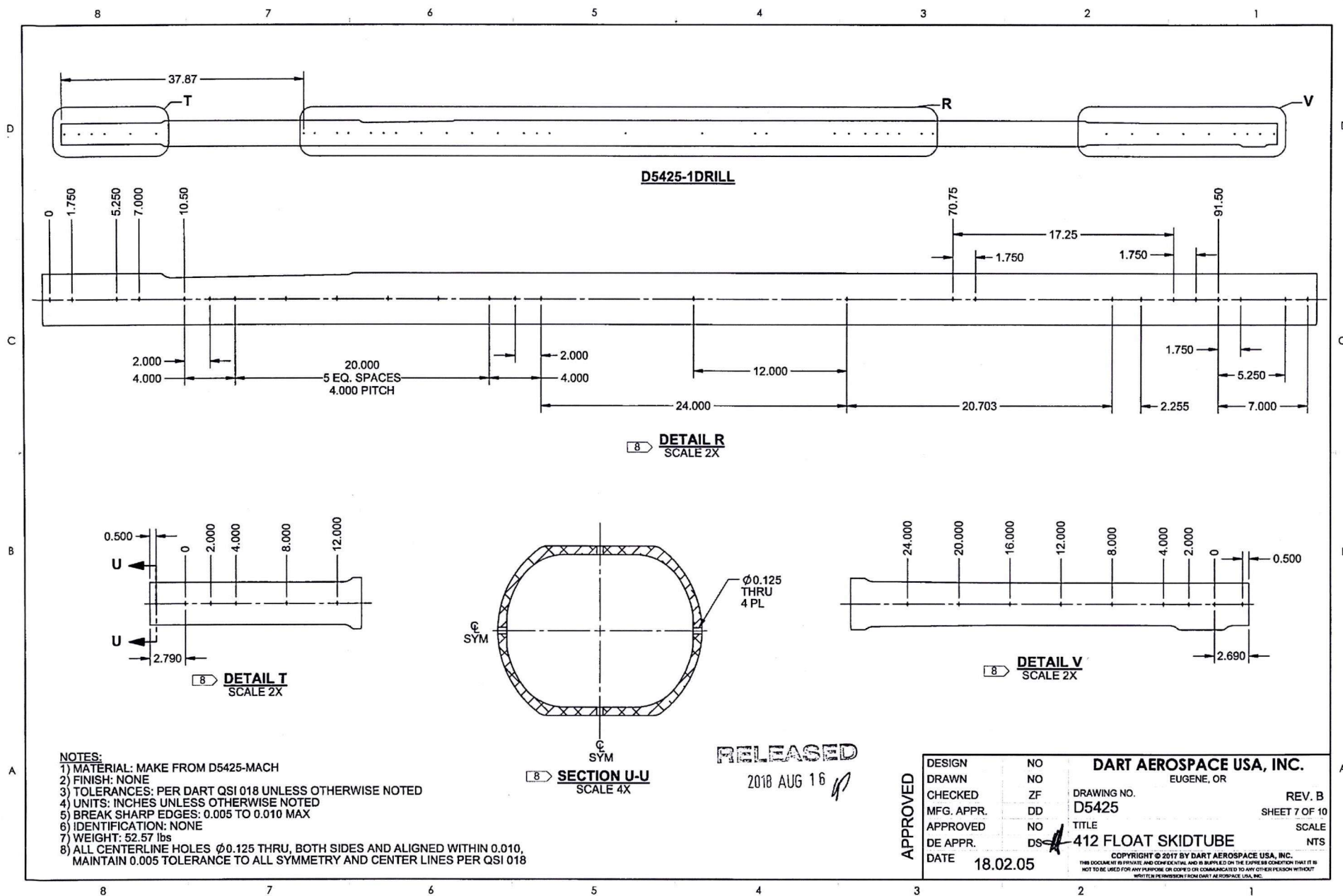
- NOTES:
- 1) MATERIAL: MAKE FROM D5425-3DRILL
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DAPT QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 32.37 lbs
 - 8) ALL HOLES THRU BOTH SIDES AND ALIGNED WITHIN 0.010
 - 9) MAXIMUM TWIST ALLOWANCE 3 PER DISTANCE FWD AND AFT BEN
 - 10) MAXIMUM 5% CRUSHING PER QSI 038 7.1

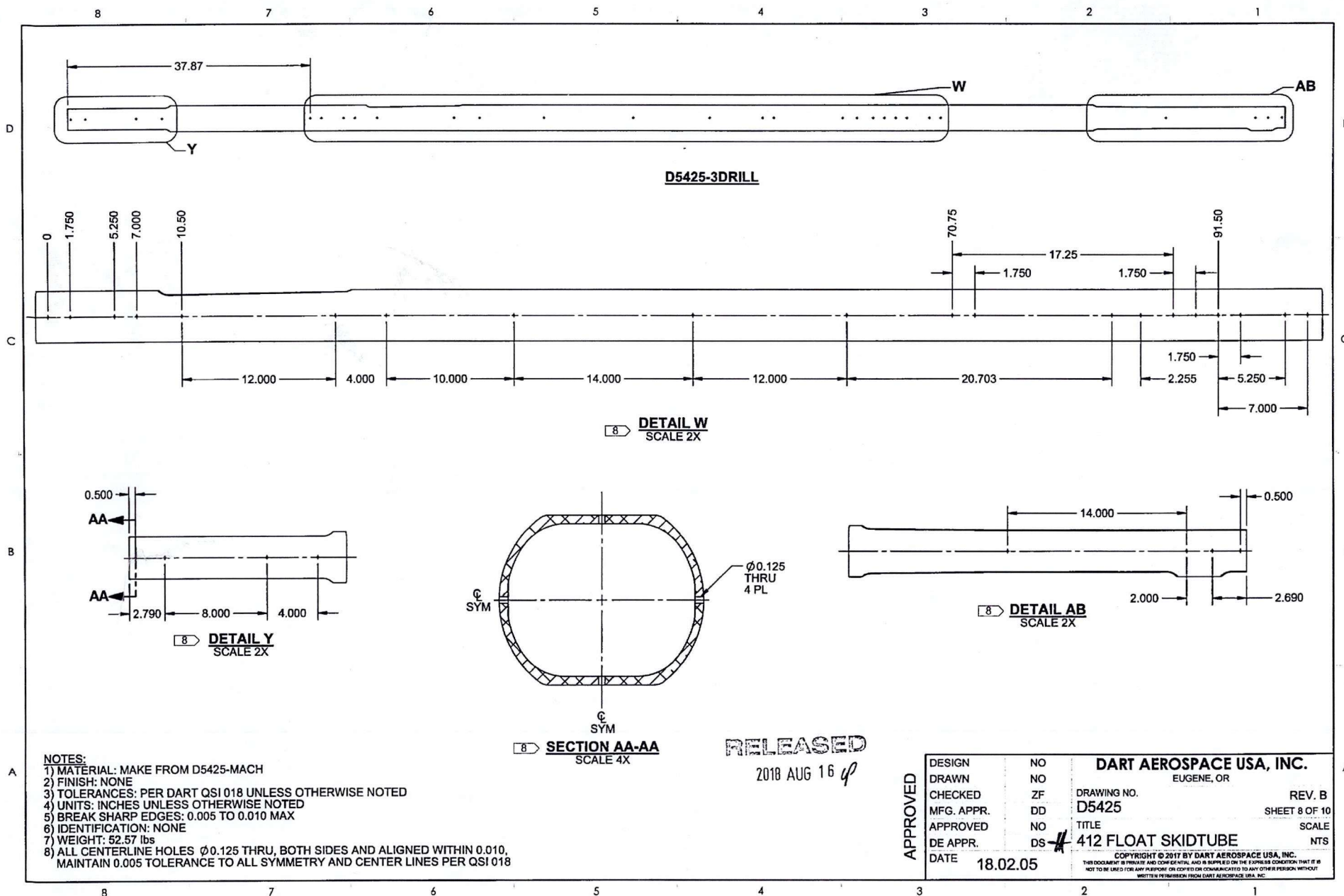
RELEASED

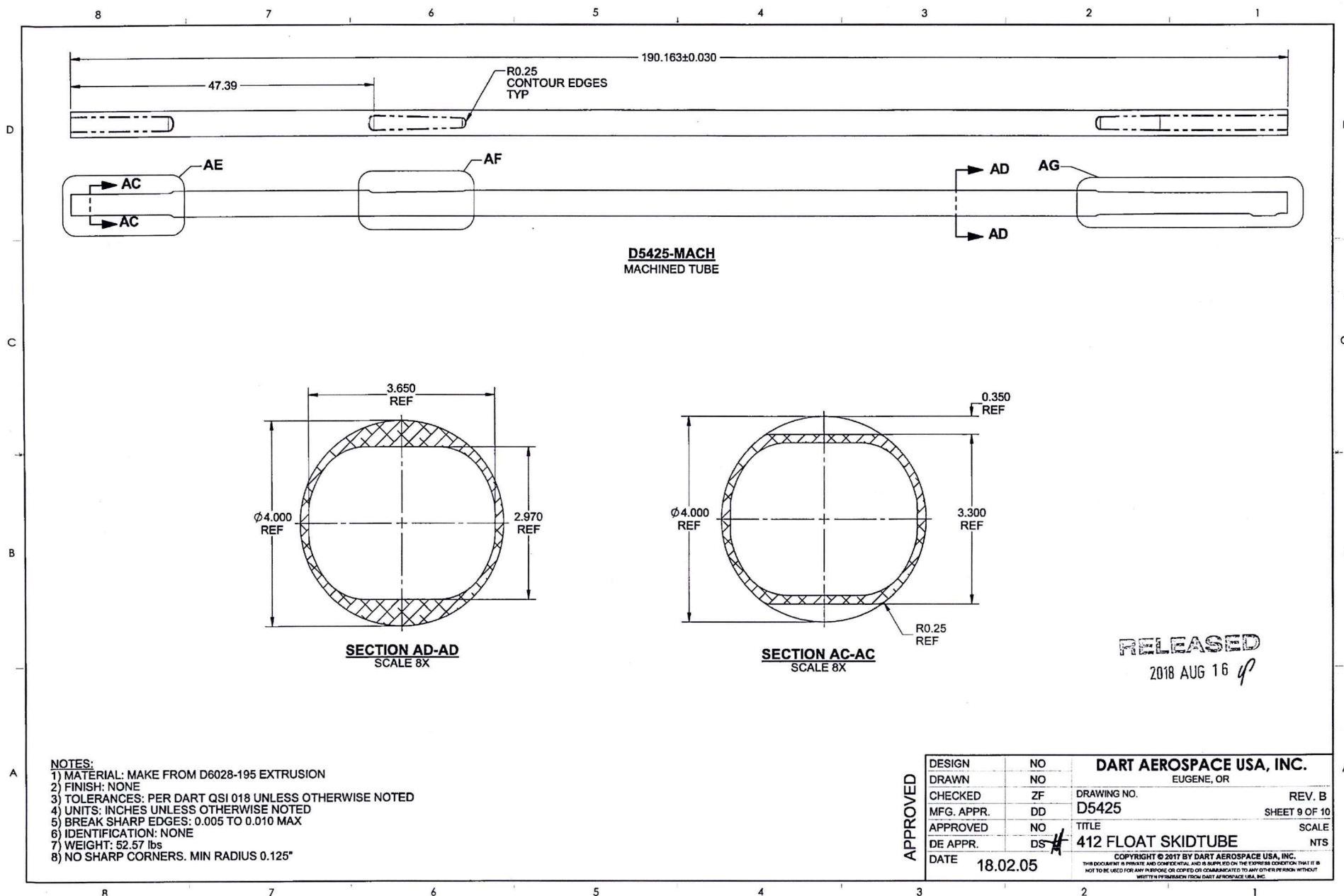
2018 AUG 16 4

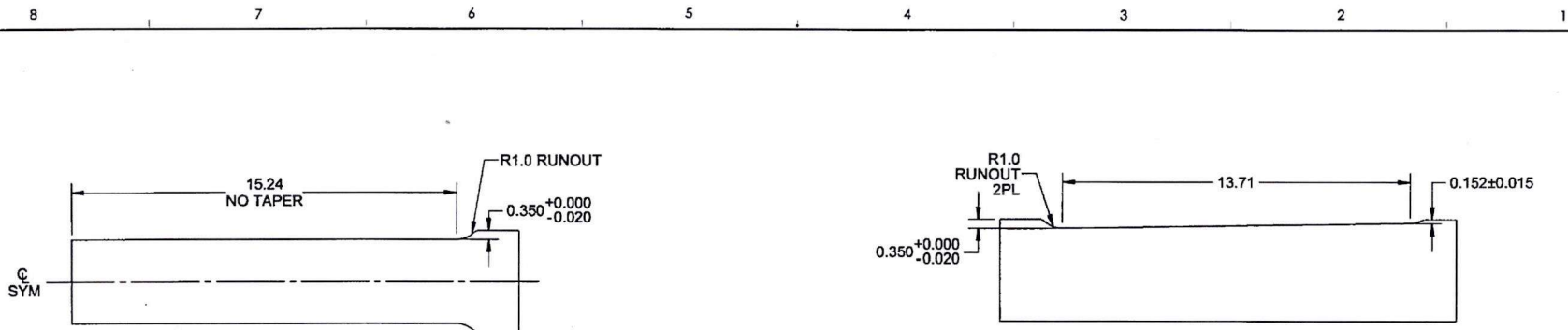
APPROVED

DESIGN		NO	DART AEROSPACE USA, INC.	
DRAWING		NO	EUGENE, OR	
CHECKED		ZF	REV. B	
MFG. APPR.		DD	SHEET 6 OF 10	
APPROVED		NO	SCALE	
DE APPR.		DD	NTS	
DATE		18.02.05	412 FLOAT SKIDTUBE	



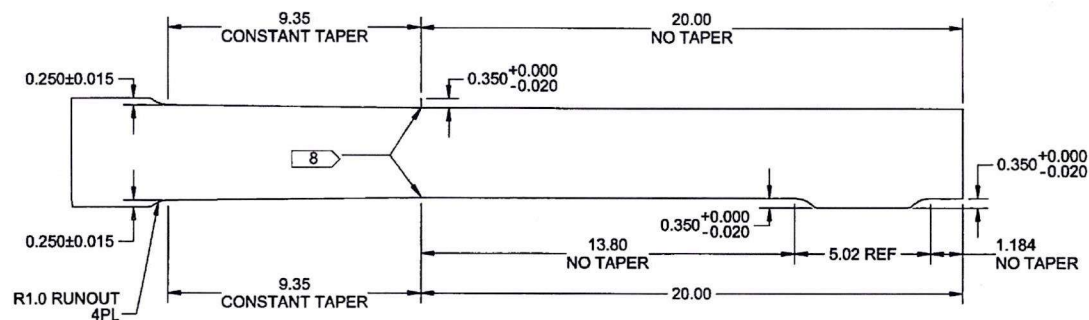






DETAIL AE
SCALE 3X

DETAIL AF
SCALE 3X



DETAIL AG
SCALE 3X

RELEASED

2018 AUG 16 *up*

APPROVED	DESIGN	NO	DART AEROSPACE USA, INC.	
	DRAWN	NO	EUGENE, OR	
	CHECKED	ZF	DRAWING NO.	REV. B
	MFG. APPR.	DD	D5425	SHEET 10 OF 10
	APPROVED	NO	TITLE	SCALE
	DE APPR.	DSS	412 FLOAT SKIDTUBE	NTS
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

DART AEROSPACE LTD		Work Order: 196257
Description: float skidtube assembly		Part Number: 05425-043
Inspection Dwg:	Rev: B	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/- .010	0.500	✓		KT-05	verm.
2.790	+/- .010	2.790	✓		Dial ind	HAAS4
10.790	+/- .010	10.790	✓		" "	" "
14.790	+/- .010	14.790	✓		" "	" "
43.120	+/- .010	43.116	✓		" "	" "
44.870	+/- .010	44.8766	✓		" "	" "
48.37	+/- .010	48.366	✓		" "	" "
60.37	+/- .010	60.366	✓		" "	" "
64.37	+/- .010	64.366	✓		" "	" "
74.37	+/- .010	74.366	✓		" "	" "
123.328	+/- .010	123.324	✓		TAPE	REF
125.87	+/- .010	125.866	✓		" "	" "
129.37	+/- .010	129.366	✓		" "	" "
131.12	+/- .010	131.116	✓		" "	" "
134.62	+/- .010	134.616	✓		" "	" "
136.37	+/- .010	136.366	✓		" "	" "
0.500	+/- .010	0.500	✓		Dial ind	HAAS4
2.690	+/- .010	2.690	✓			
4.69	+/- .010	4.690	✓			
18.69	+/- .010	18.690	✓			
15.24	+/- .030	15.240	✓		TAPE	REF
R1.0	+/- .100	R1.000	✓		R-G	REF.
0.350	+0.000 / - .020	0.338	✓		ind dial	HAAS4.
0.350	+0.000 / - .020	0.340	✓		" "	" "
R1.0	+/- .100	R1.00	✓		R-G	REF.
13.71	+/- .030	13.710	✓		TAPE	REF.
0.152	+/- .015	0.142	✓		dial ind.	HAAS4.
0.250	+/- .015	0.240	✓		" "	" "
9.35	+/- .030	9.35	✓		TAPE	REF.
0.350	+0.000 / - .020	0.344	✓		dial ind	REF.
20.00	+/- .030	20.00	✓		TAPE	REF.
0.250	+/- .015	0.241	✓		dial ind	REF.

Measured by: KT	Checked by: [Signature]	QC Inspector:
Date: 19-07-18	Date: 19/07/22	Date:

Engineering Approval: (if necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	